

Date: Wednesday, 7/4/2007 10:17:33 AM
User: Kim Johnston

Process Sheet

SPLIT-D

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	33285		
Estimate Number	12711		
P.O. Number	N/A	Part Number	D35373
This Issue	7/4/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3537 REV C
First Issue	N/A	Project Number	N/A
Previous Run	32789	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By	HJ 07.07.04	Due Date	7/22/2007
Comment	Est Rev.A New Issue 07-02-14 JLM	Qty:	40
		Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304S16GA	304/316 .063 Sheet	
		Comment: Qty.: 0.1512 sf(s)/Unit Total: 6.0480 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M105061	SAD 07/07/20
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C	SAP 07/07/20 47
		2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/07/20 47
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	Sp 07/07/23 47
5.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3 Form Joggle as per Dwg D3537 on brake using Jig DT8158	FF 07-08-07 47 Sp 07/08/08 47

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes Yes No No DQA: RD Date: 27/08/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WEARPAD
Job Number: 33285		Part Number: D35373
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP Ensure joggle as per dwg D3429		 Sp 07/08/08 (27) X48
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1 Qty Description Batch A/R 2059B Hardcoat <u>2059B</u> Weld hardcoat as per Dwg D3437		 JF 07/08/16 (27) FC 07/08/15
8.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		 M 07/08/18 (27)
9.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 M 07/08/12 (27)
10.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3		 m/04846 (27) FL 07/08/21 (27)
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 M-f 07/08/21 (27)
12.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: FP/18		 BP/M-f 07-08-21 (27)
13.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 R 07/08/22 (27)
Job Completion		 J 07.08.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33285
Description: Wearpad	Part Number:	D3537-3
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

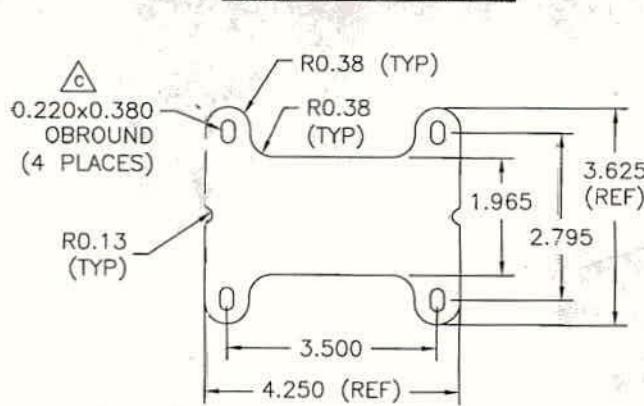
X First Article Prototype

Measured by:	SAD	Audited by:	Sn	Prototype Approval:	N/A
Date:	07/07/20	Date:	02/07/23	Date:	N/A

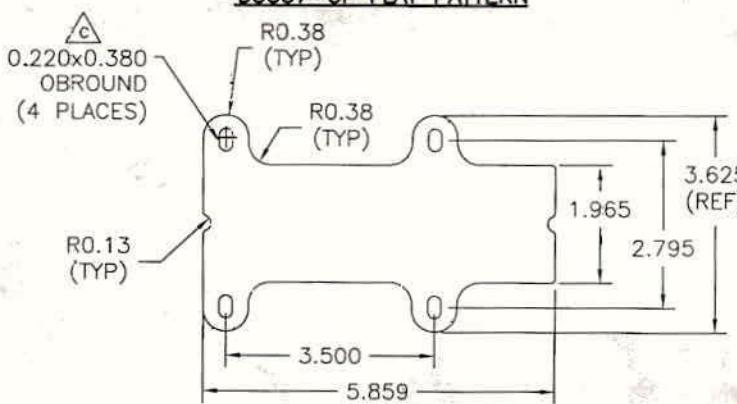
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E



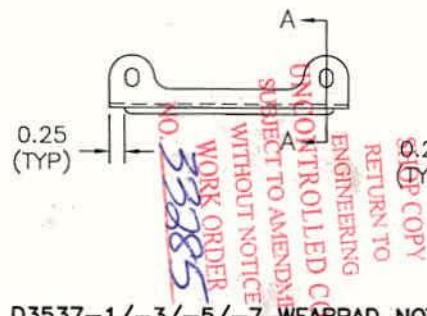
D3537-1F FLAT PATTERN



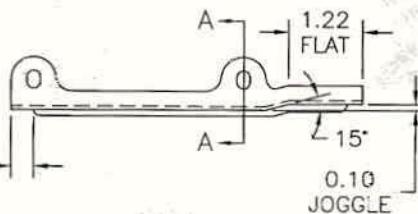
D3537-3F FLAT PATTERN



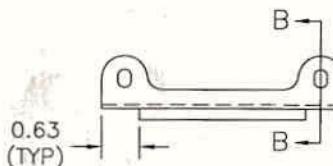
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-1/-3/-5/-7 WEARPAD NOTES

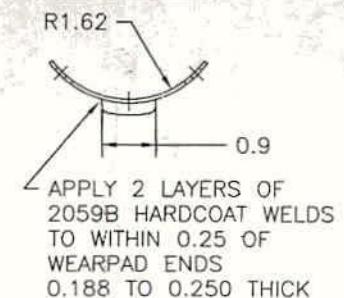
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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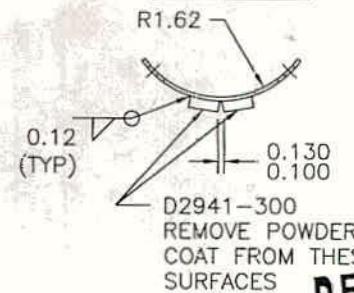
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C	07.04.13	WIDEN TAB TO C.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537 REV. C SHEET 1 OF 1
DATE	TITLE	SCALE 1:1
07.04.13	WEARPAD	

SECTION A-A



SECTION B-B



RELEASED
07.05.08 AM
per ECN
952

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

